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5 The screw 72 is threaded through the left (as viewed in FIG. 1) end of the rear wall 56 so a piece of work (not shown in FIG. 1) can be clamped within the jig between the front and rear walls.

10 The jig shown in FIGS 1-3 is used by placing the jig in the position shown in FIG. 1, and thereafter placing an elongated pipe (not shown) or other piece of work having a central longitudinal axis (not shown) in the jig and clamping the work in the jig with work clamp 70. The table clamping plate 30 is then adjusted to drive it forward against the rear wall 56 of the jig, causing the guide pin 60 to slide forward (to the right as viewed in FIG. 1) until the aligning surface 64 along the forward edge of the angle-setting projection 62 contacts the backup plate, which is set in the 0° position so that the backup plate 20 is perpendicular to the cutting plane of the saw. The angle of the aligning surface 64 with respect to the work surface 58 of the forward wall of the jig and causes the jig and clamping plate 30 to rotate in a counterclockwise (as viewed from above) direction around the guide pin 60 and vertical shaft 34 until the clamp 30, jig, work, and angle-setting projection are all firmly locked in the position shown in FIG. 1. The angle between the aligning surface 64 and the major plane of work surface 58 can be any desired amount. However, 30° is a good angle for forming a saddle 74 on the end of a pipe 75 or cylindrical tube so the end of the pipe with a saddle makes a snug fit perpendicular to a similar piece of tubing 76 as shown in the photograph of FIG. 10. The saddle is formed by first cutting the pipe or tubing at an angle of 30° thereafter rotating the pipe in the jig 180° about the longitudinal axis of the pipe, and making a second cut at 30°.

35 Typical dimensions of the jig are as shown on FIGS. 2 and 3, which also show that the jig base plate 52, rear wall 56, and forward wall 58 are conveniently formed by bending a single piece of rectangular plate into a U-shape.